

ABSTRACT

5 An internal surface chucking mechanism (ISM) for gripping and for releasing an
internal surface of a workpiece (W) in process on a processing machine is configured
for reversible exchange with an external surface chucking mechanism (EXS)
dedicated to grip an external surface of the workpiece. The ISM fits machinery where
the workpiece is rotating and is non-rotating, in a first mode with the EXS, and in a
second mode with the ISM, and *vice-versa*. A fluid conduit inside the ISM provides
10 fluid, such as oil, for exhaust adjacent and opposite the workpiece. An appropriately
oriented exit outlet (353) directs a stream of fluid to impinge on the workpiece, to
eject it from the ISM when released from grip. The fluid cools and lubricates both the
ISM and the workpiece.